

Date: Thursday, 22/01/2009 8:43:18 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SLIDING DOOR BRACKET
 Job Number : 45062
 Estimate Number : 13643
 P.O. Number :
 This Issue : 22/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D36753
 Drawing Number : D3675 REV B
 Project Number : N/A
 First Issue : / / Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 44875 Material :
 Due Date : 23/01/2009 Qty: 20 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A new issue 08-11.06 EC verified by:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet

wrong →



MAT NOT PULLED



Comment: Qty.: 0.1271 sf(s)/Unit Total: 2.5410 sf(s)

wrong →

304 stainless steel 0.032" Sheet

H0076 204

Batch:

~~10057~~ IB 9-1-22 109057

P10

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3675

Dwg Rev:

Prog Rev:

IB 9-1-22

24

2-Deburr if necessary

IB 9-1-22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 9-1-22

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

809/01/22

counters

24

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3675

SB 09/01/22 24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3675-3 PAR #: N/A Fault Category: Prod. Eng. Coord. NCR: Yes No DQA: NA Date: 09-01-29
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: PD Date: 09/02/09

NCR: 45062		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/1/22	#1.0	During inspection found that the mat. thickness is 0.030". Dwg calls for 0.040". R.C. water Jet operation pulled	<i>[Signature]</i>	SCRAP and Destroy all Qty 28 parts and replace with correct mat.	<i>[Signature]</i> 9-1-22	<i>[Signature]</i> 09/01/22	<i>[Signature]</i>	<i>[Signature]</i> 09/01/22
		He mat. with out checking the Dwg. also he comments on the w/p are wrong. → Should read M3045194A	<i>[Signature]</i>	304 stainless steel 0.040" M# 110676 -Remind employee to read Dwg	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i> 09/01/22
		304 Stainless Steel 0.040"	<i>[Signature]</i>	Fix comments on w/p to read correct mat. Thickness	<i>[Signature]</i> 09/01/22	<i>[Signature]</i> 09/01/22	<i>[Signature]</i>	<i>[Signature]</i> 09/01/22

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 8:43:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING DOOR BRACKET

Job Number: 45062

Part Number: D36753

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Serial 22 counters
(x24)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 7:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:00AM

M1109648

09-01-23 x24

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 09/01/23 (24)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 238A

AS 09/01/23 x24

~~PPP PPP 4298 XII~~

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/27

Job Completion



h 09.01.27

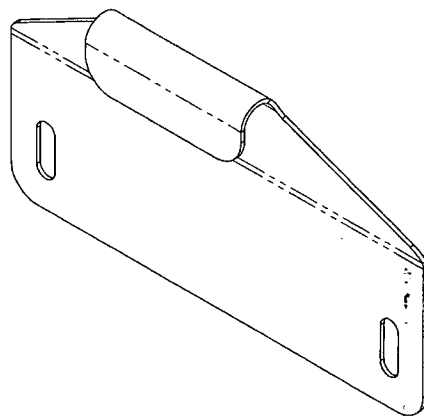
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

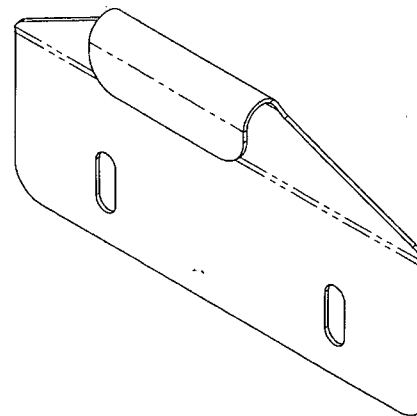
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3675-1 SLIDING DOOR BRACKET



**D3675-3 SLIDING DOOR BRACKET
(HINGE PANEL MOD)**

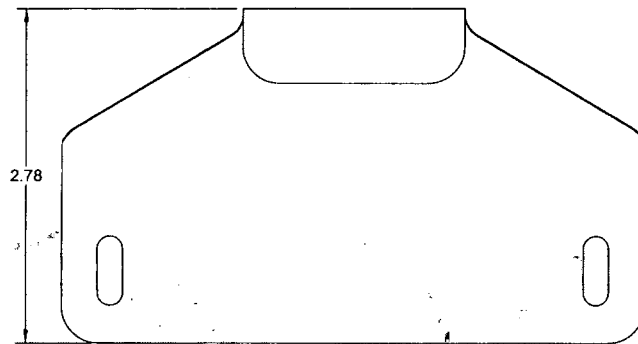
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED)
REF. DART SPEC M304S
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

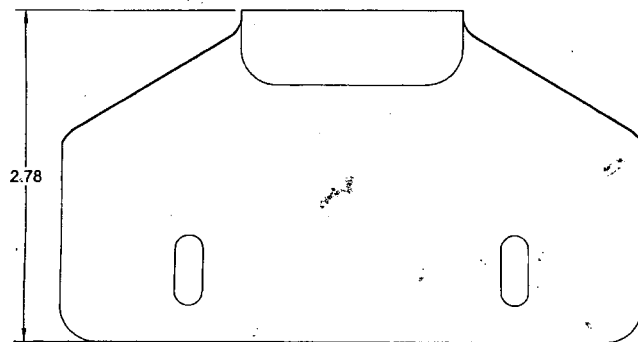
Handwritten signature/initials

RELEASED
08.11.10

B	ADD -3 FOR HINGE PANEL MOD.	AJS	08.11.03
A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3675	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SLIDING DOOR BRACKET SCALE
DE APPR.	<i>[Signature]</i>	(COMPOSITE DOOR)	NTS
DATE	08.11.03	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

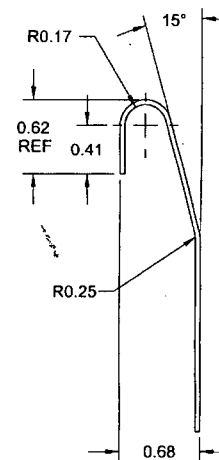
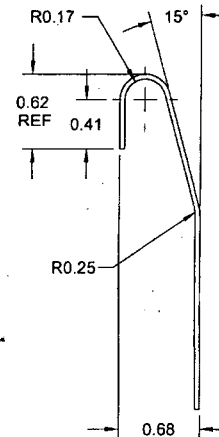


D3675-1 SLIDING DOOR BRACKET
(MAKE FROM D3675-1F)



D3675-3 SLIDING DOOR BRACKET
(MAKE FROM D3675-3F)
(HINGE PANEL MOD)

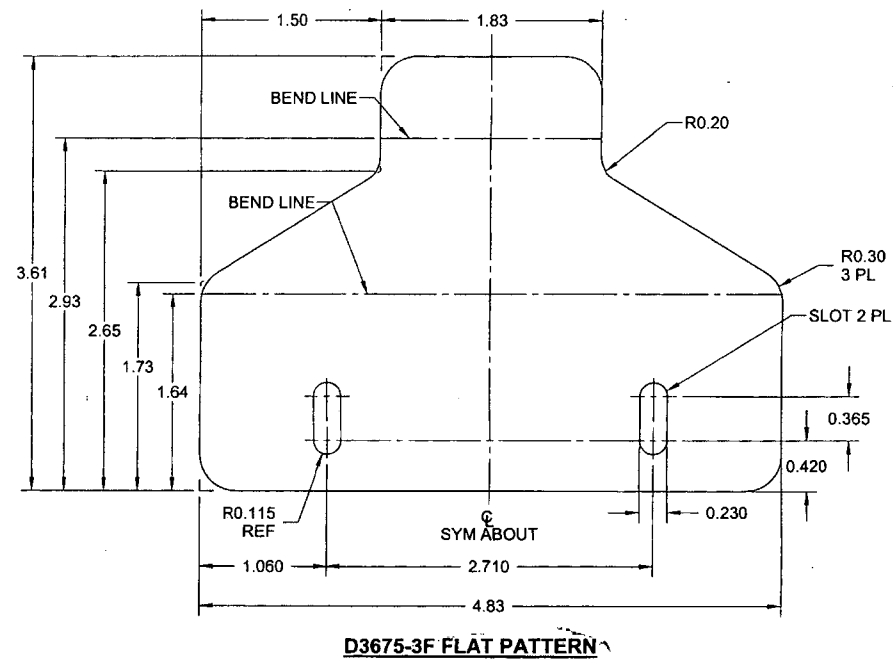
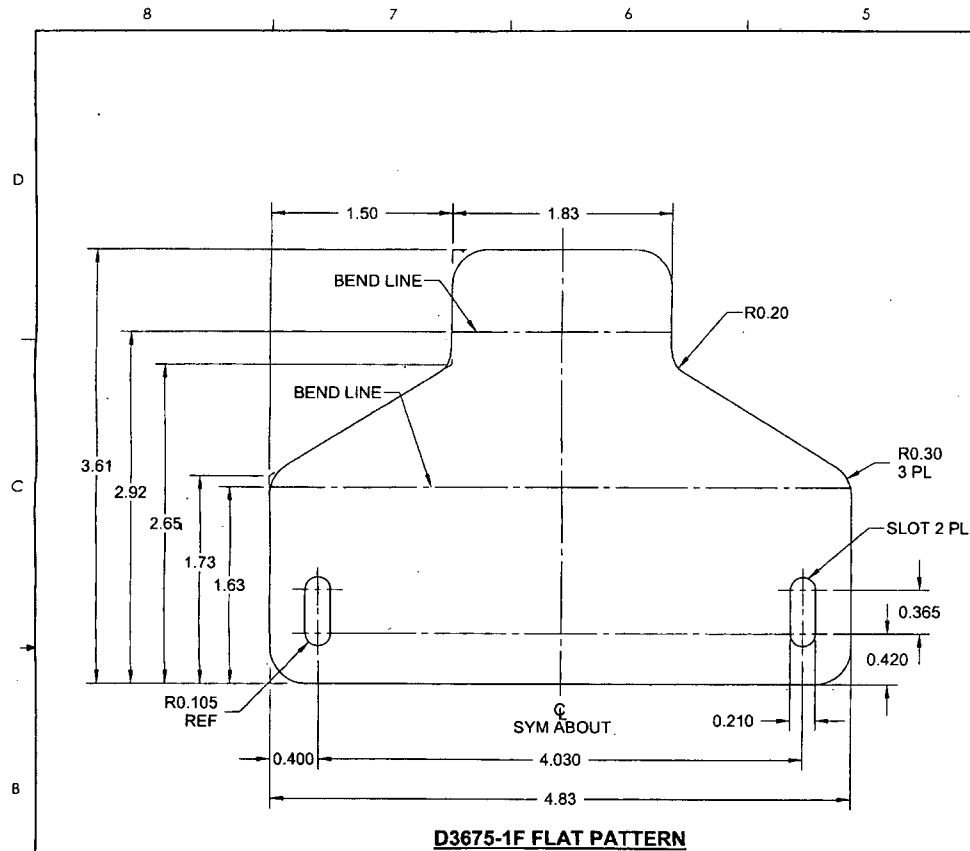
45062



RELEASED
08.11.10





DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3675	SHEET 2 OF 3
APPROVED		TITLE	SLIDING DOOR BRACKET
DE APPR.		(COMPOSITE DOOR)	SCALE
DATE	08.11.03		NTS

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RELEASED
08.11.10

45062

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B	
DRAWN	AJS			
CHECKED		DRAWING NO. D3675	SHEET 3 OF 3	
MFG. APPR.		TITLE SLIDING DOOR BRACKET (COMPOSITE DOOR)	SCALE NTS	
APPROVED				
DE APPR.		COPYRIGHT © 2006 BY DART AEROSPACE LTD		
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